

Ship NOV. 15

Work Order ID 153181

153181

Page 1

Wednesday, November 09, 2016 9:07:50 AM

Item ID: D3889-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Panel Floor - Sub-Component Of#D350-766-021
 Start Date: 11/9/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/14/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan:  Date: 16-11-09 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3889	A						DAS 46 9-89	16/11/09	

100

0.01

100

Waterjet

Memo

0.06

FLOW CNC Waterjet

1-Cut as per Dwg D3889-1

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									DAS
QC	Memo	0.00				1			38
Quality Control									9-89
									NOV 11 2016
130		0.00							
130									
Small Fab	Memo	0.17							
Small Fab	Deburr if necessary								
140	Pick Kit	0.00							
140									
Packaging	Memo	0.00							
Packaging									

1 FF NOV-11-16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Wednesday, November 09, 2016 9:07:50 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Start Date: 11/9/2016 **Start Qty:** 1.00 ***1***

1

Required Date: 11/14/2016 **Req'd Qty:** 1.00 ***1***

1

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

0.00

150

0.09

Memo

1- Bond gasket to smooth side of panel as per dwg
A/R 3M 1300 adhesive Batch: 1713487

0.00

1 60

0.00

Memo

DAS
38
9-89
NOV 11 2016

0.00

170

0.00

Memo

NOV 15 2016

1 DAS
6
9-89

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

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180	QC21- Final Inspection - Work Order Release	0.00							
180						DAS			
QC	Memo	0.02				21			
Quality Control						9-89		NOV 15 2016	

DAS
21
9-89 NOV 15 2016

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Picklist Print

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Parent Item: D3889-041

D3889-041

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Required Date: 11/14/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	1,330.702	8.1925	9.638235			
MI FXS 125-F60029-04									**				
GE PLASTICS LEXAN SHEET (DARK GREY)													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					MAT018			1330.702353					
					m135074			1330.70235					
D3889-3		Manufactured	No			140	Each	4.0000	1	1			
D3889-3									**				
Gasket													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST508A			4					
					147114			4					

DAS
46
9-89

16/11/09

FF NOV 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

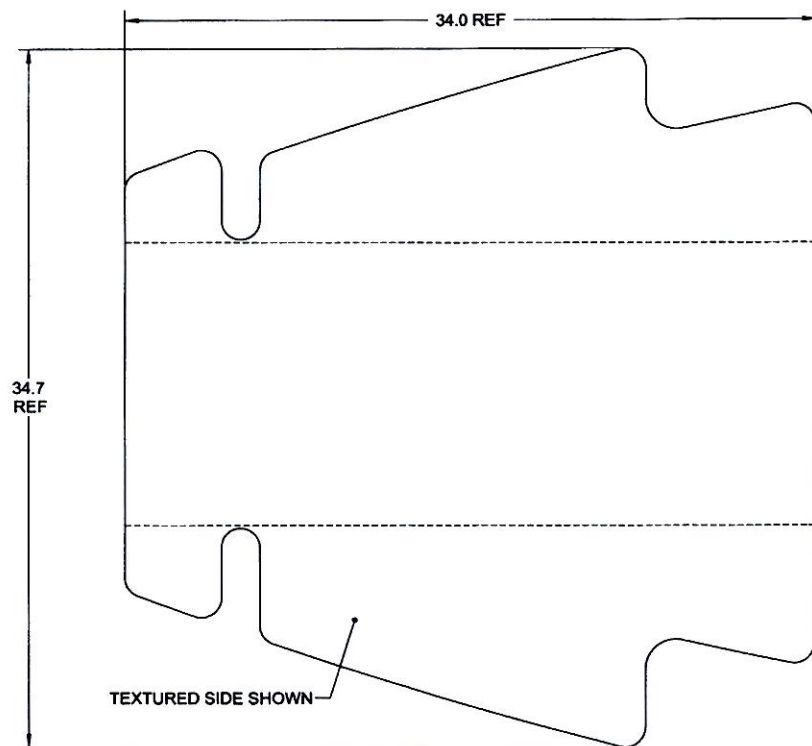
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition																					
								Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																			

PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3889-041	PANEL, FLOOR
2	1	D3889-1	PANEL
3	1	D3889-3	GASKET
4	A/R	3M 1300	ADHESIVE

**D3889-041 PANEL, FLOOR**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3889-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 5.13 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

D3889-1 PANEL

D3889-3 GASKET

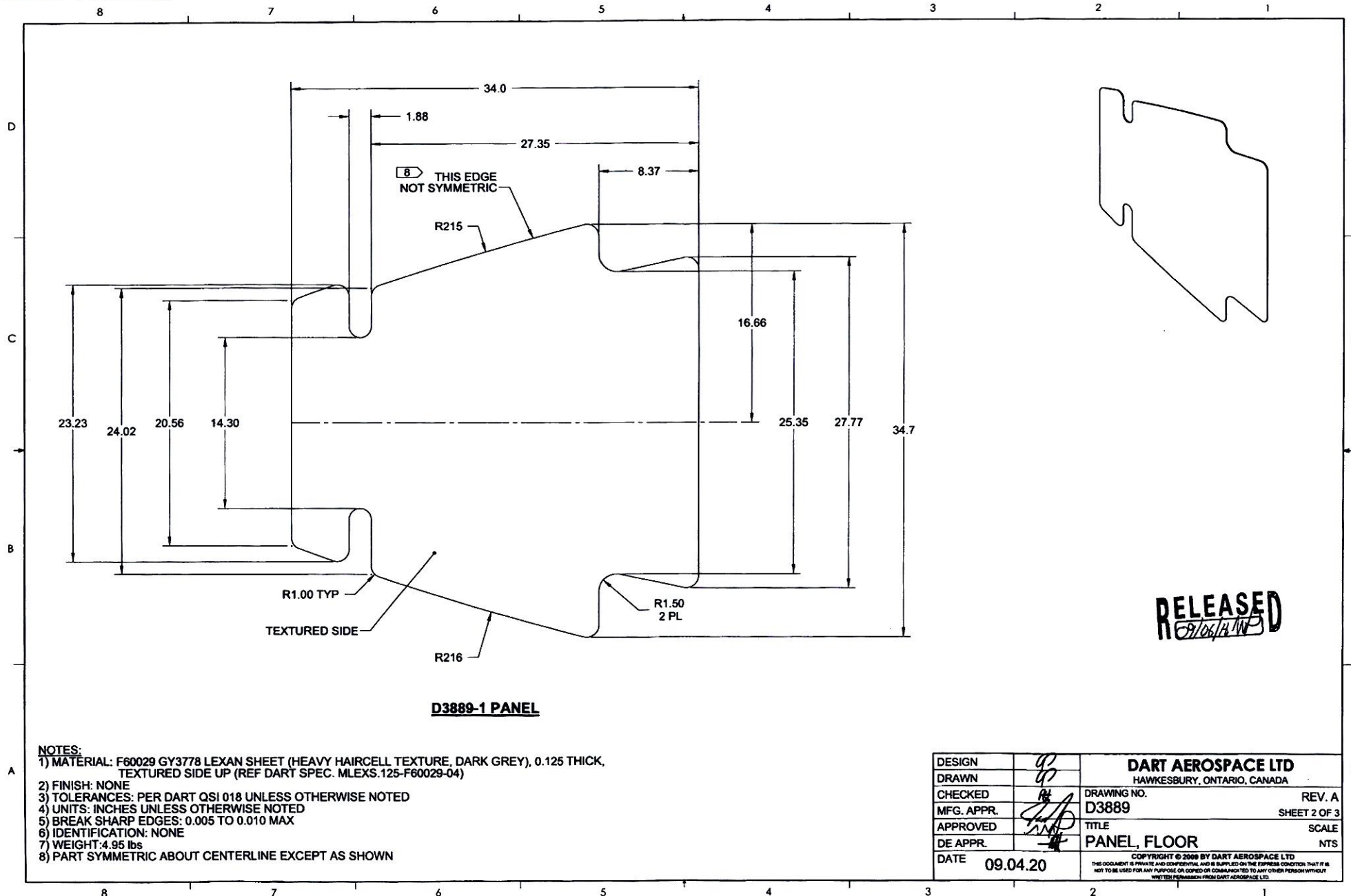
8

8

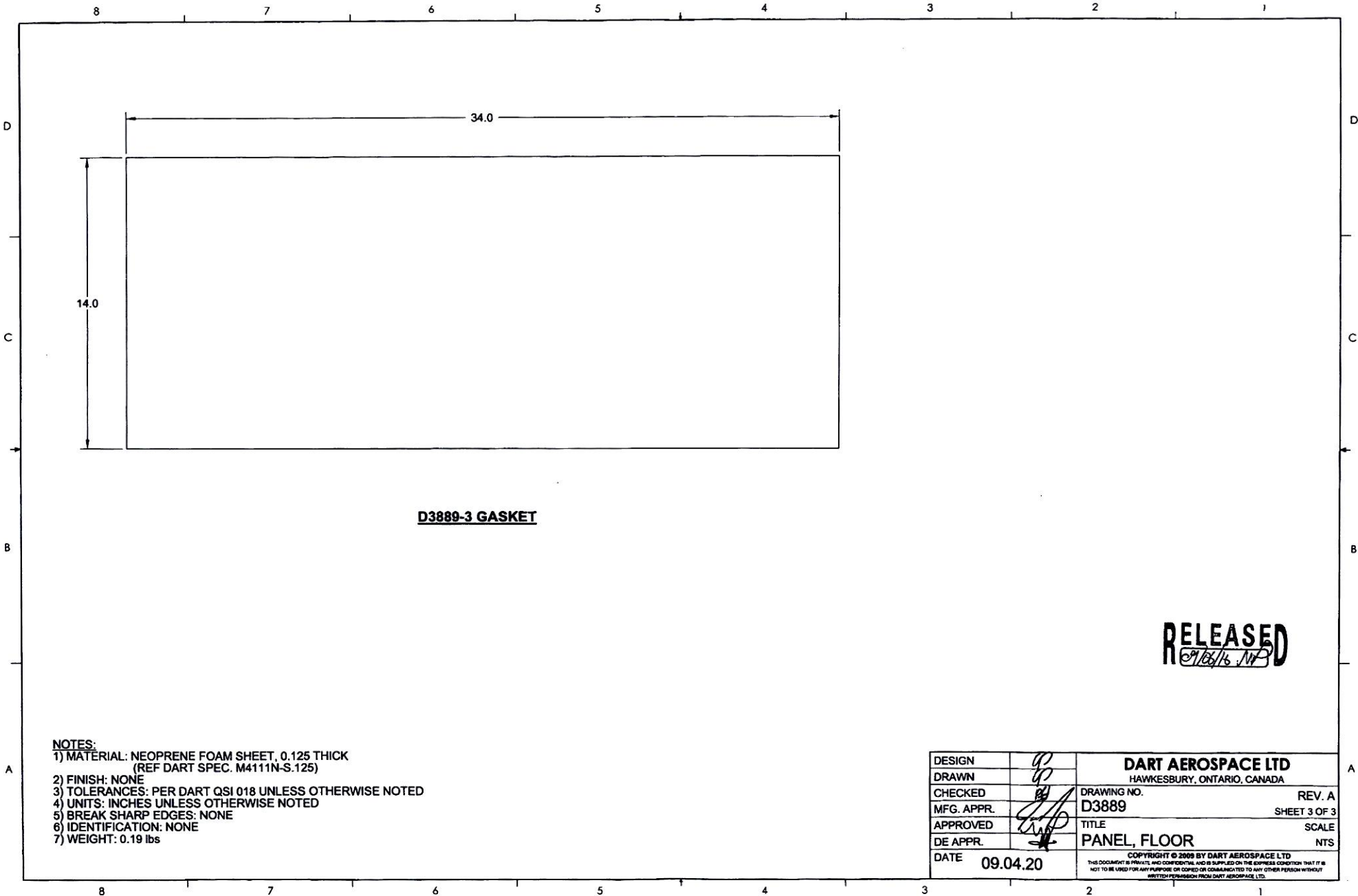
SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153181
MP 16-11-09

RELEASED
09/04/20

A	NEW ISSUE	CP	09.04.20
REV.	DESCRIPTION		BY DATE
DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3889 TITLE PANEL, FLOOR COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	REV. A
DRAWN	92		SHEET 1 OF 3
CHECKED	92		SCALE
MFG. APPR.	92		NTS
APPROVED	92		
DE APPR.	92		
DATE	09.04.20		



DESIGN	95	DART AEROSPACE LTD	
DRAWN	95	HAWKESBURY, ONTARIO, CANADA	
CHECKED	95	DRAWING NO. D3889	REV. A
MFG. APPR.	95	SHEET 2 OF 3	
APPROVED	95	TITLE	SCALE
DE APPR.	95	PANEL, FLOOR	NTS
DATE	09.04.20	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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NOTES:

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

RELEASED
P/B/L/s M/P

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3889	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		PANEL, FLOOR	NTS
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